

Work Order ID 90641

90641

Page 1

September-21-12 11:28:40 AM

Item ID: D3030-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lock
 Start Date: 9/25/12 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 9/25/12 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-09-21 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3030	Rev A

100 PURCHASING 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 17983 a) Possible supplier: Northern Aero Industries b) Order P/N B83603-1 c) Material: 2024-T351 (QQ-A-225/6) d) 0.010" max diff. Between 0.525" dim each side e) All diameters concentric within 0.005 T.I.R f) All dimensions are in inches g) Tol

CZ 12/09/21 (12)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

12/11/16 (12)

120 QC6- Inspect dimensions to drawing 0.00
 120
 QC Memo 0.00
 Quality Control

DAS 16 12/16/12

(X17)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 90641***90641***

Page 2

September-21-12 11:28:40 AM

Item ID: D3030-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock

Start Date: 9/25/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/25/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location *ES 24* 0.00***130***

Packaging

Memo

0.00

Packaging

*12x**SP
12-10-17*

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

*12/10/18 DJ**12-10-17*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

September-21-12 11:28:40 AM

Page 1

Work Order ID: 90641

Parent Item: D3030-1

Parent Item Name: Lock

Start Date: 9/25/12

Required Date: 9/25/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B 01.06.08 Removed chemical conversion EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B83603-1 Lock		Purchased	No			110	Each	0.0000	1	12		4/24/16	(12)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

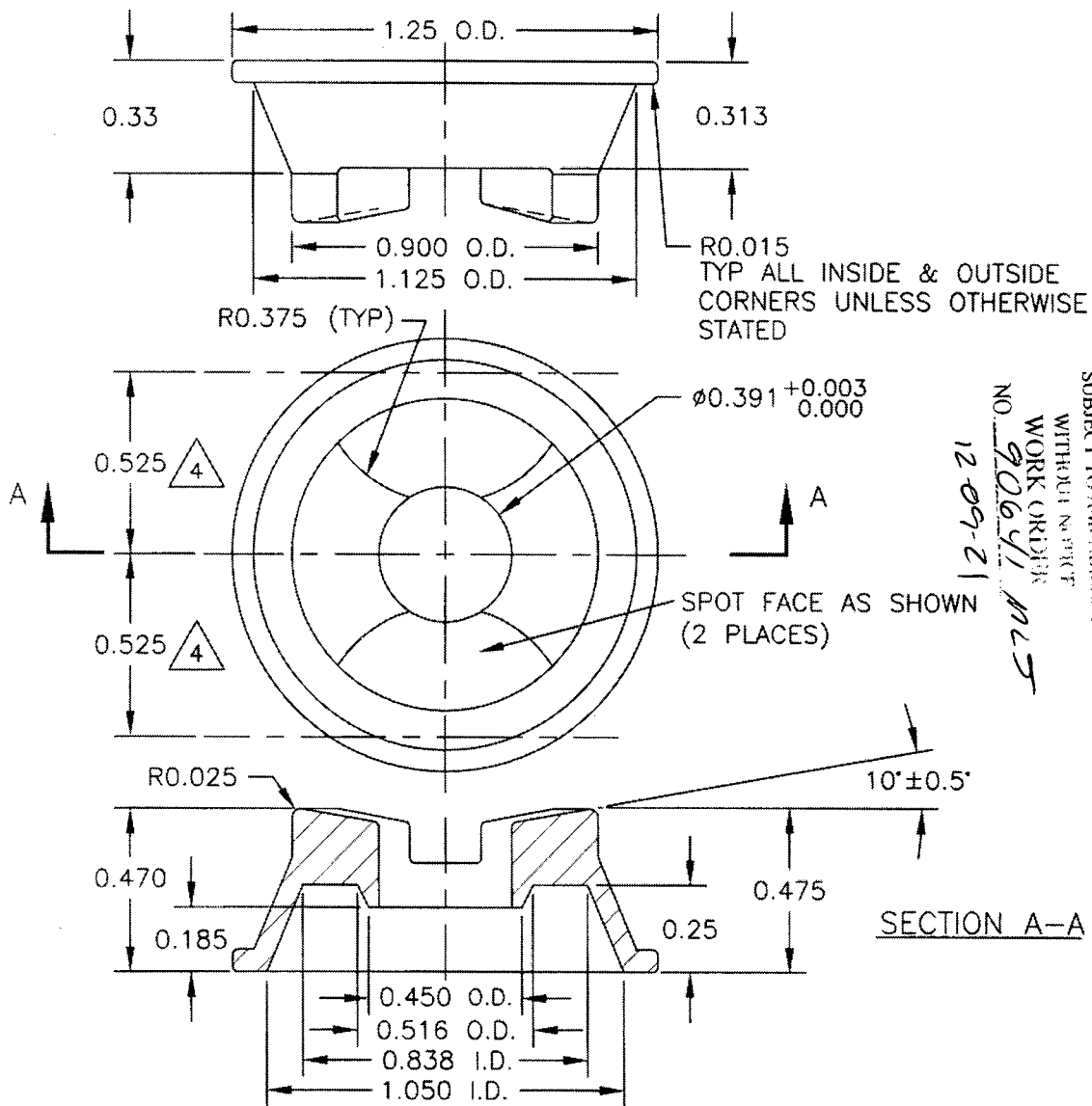
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3030	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE LOCK	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3030-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83603-1
- 2) MATERIAL: 2024-T351 (QQ-A-225/6)
- 3) ALL DIAMETERS CONCENTRIC WITHIN 0.005 T.I.R.
- 4) 0.010 MAX DIFF. BETWEEN 0.525 DIM EACH SIDE.
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.05.30

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17983

Purchase Order Date 9/24/12

PO Print Date 9/25/12

Page Number 1 of 1

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2
CA

Contact Name

Vendor Phone

204-772-9922

Vendor Fax

204772-7568

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

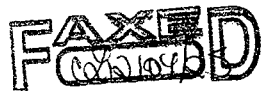
FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	B83603-1	Lock	10/12/12 Yes	12.00 Each	FedEx PI collect	\$85.0000	\$1,020.00

Special Inst: AS PER DWG D3030 REV. A
B90641

MATERIAL: 2024-T3 AS PER QQ-A-225/6
0.010" MAX DIFF. BETWEEN 0.525" DIM.
EACH SIDE
ALL DIAMETERS CONCENTRIC WITHIN
0.005 T.I.R
ALL DIMENSION ARE IN INCHES

3	B83605-1	SPRING	10/12/12 Yes	20.00 Each	FedEx PI collect	\$12.0000	\$240.00
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Special Inst: AS PER DWG D3029 REV. A
B90659

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL: Ø0.041" PIANO WIRE
DIMENSIONS: MEAN DIA. = 0.625"
PITCH = 0.20" LENGTH = 1.20"
ALL DIMENSION ARE IN INCHES

PO Total:

\$1,260.00

CL

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES **NO**

Change Nbr: 2

Change Date: 9/25/12

ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 3169
Delivery Date : 10/15/2012
SO No. : 27582
Your Reference : PO: 17983
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total		Qty		Delivery Date
		Ordered	Unit	Delivered		
B83605-1	SPRING 12-3866	20	EA	20		10/15/2012
B83603-1	LOCK 11-4297 12-3345	12	EA	12		10/15/2012
Ship via FedEx P1 to account # 151793240 Email: clavoie@dartaero.com Ph: 613-632-9577						
Packages: 0 Gross Weight: 0.00 Net Weight:						

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

0.00

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:



Engineering, Certification & Manufacturing

25 Dunlop Ave
Winnipeg, Manitoba, Canada, R2X 2V2
Ph: 204-772-9922 Fax: 204-772-7568

CERTIFICATE OF CONFORMITY

Form Tracking No. 27582-1

Work Order/Contract/Invoice: PO 17983

Cage Code: MFR L0555

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Lock	B83603-1	2	11-4297	New
2	Lock	B83603-1	10	12-3345	New
3	Spring	B83605-1	20	12-3866	New

Remarks:

THESE ITEMS CONFORM TO DESIGN DATA B83603 (REV. NC) AND B83605 (REV. NC), AS APPLICABLE.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)
15-Oct-12

Used, Repaired or Overhauled Parts Certification

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.